

Work Order ID 111115

111115

Page 1

Thursday, January 09, 2014 11:28:40 AM

Item ID: PB67-43001-13 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 1/8/2014 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: ME Date: 14-01-09 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-13	Rev C								
100	Large Fab	0.00							
100	Large Fab	0.00							
Large Fab	Memo								
Large Fab	1- make a 0.090" chamfer in the 1.00" hole before welding								
	2- assemble parts and weld as per dwg								
	3- grind weld flush in area of PB67-43001-249 only								
	4- install helicol insert as per dwg								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110	QC	0.00							
Quality Control	Memo								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC	0.00							
Quality Control	Memo								

DAS
27
1-19
1/2/12

14-02-12

14-2-12

Work Order ID 111115

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Page 2

Item ID: PB67-43001-13 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
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 Start Date: 1/8/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	N/A			1	1		DAS 19 9-89 14-02-13
160 *160* Powdercoat Powder Coating	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo 1- MASK TUBES FROM BASE TO GUSSET START TIME: 8:15 OVEN TEMPERATURE: 320° FINISH TIME: 9:15	0.00 0.00				1	1	14-2-13	DAS 34 9-89
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1	1		DAS 19 9-89 14-02-13

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 1/8/2014 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 1/24/2014 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

0.00

180

Small Fab

0.00

Small Fab

Memo

Small Fab

1- match drill cover to existing holes in support
2- assemble as per dwg

14-02-13

190

QC5- Inspect part completeness to step on W/O

0.00

190

OC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: W403 0.00

0.00

200

Packaging

Memo

0.00

Packaging

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Page 4

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Accept

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Stop ***NS2***

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Start Date: 1/8/2014 Start Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

*14-02-19**MF
14-2-18*

Picklist Print

Thursday, January 09, 2014 11:28:39 AM

Page 1

Work Order ID: 111115

Parent Item: PB67-43001-13

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec IPP RevC 10.09.27 per RevC
EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-67 90° Blade Support Assembly		Manufactured	No				Each	1.0000		1		14.02.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2 111266		1							
				106345		1							
PB67-43001-249 Inner Tube Bushing		Manufactured	No			100	Each	2.0000	1	1		14.02.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2 B110600		2							
				99974		2							
PB67-43001-253 Gusset		Manufactured	No			100	Each	8.0000	1	1		14.02.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		8							
				99973		8							
PB67-43001-254 Gusset		Manufactured	No			100	Each	9.0000	1	1		14.02.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		9							
				108308		9							
PB67-43001-255 Inner Tube		Manufactured	No			100	Each	1.0000	1	1		14.02.12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz2		1							
				99971		1							

Picklist Print

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Page 2

Work Order ID: 111115

Parent Item: PB67-43001-13

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Qty: 1.00

Required Qty: 1.00

MS124780	Purchased	No	180	Each	37.0000	1	1	<i>14.02.12</i>
HELICAL INSERT								

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST331	37				
			111064	37				
MS27039-1-10	Purchased	No		180	Each	256.0000	8	8
SCREW								<i>14.02.13</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	100				
			120449	100				
			ST506	156				
			m126474	156				
NAS1149D0316J	Purchased	No		180	Each	135.0000	8	8
Washer								<i>14.02.13</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			ST294	135				
			123482	135				
NAS1149D0363J	Purchased	No		180	Each	3,689.0000	8	8
Washer								<i>14.02.13</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			GA	154				
			124392	154				
			ST510a	3535				
			m126319	2335				
			m127813	1200				
PB67-43001-69	Manufactured	No		180	Each	7.0000	1	1
90 Degree Cover Plate								<i>14.02.13</i>

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			Mezz2	7				
			100027	7				

Picklist Print

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Page 3

Work Order ID: 111115

Parent Item: PB67-43001-13

Start Date: 1/8/2014

Required Date: 1/24/2014

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-83

Manufactured No

180

Each

16.0000

1

1

D-Pad Assembly, Short

14.02.13

Location

Loc Qty

Loc Code

Mezz2

16

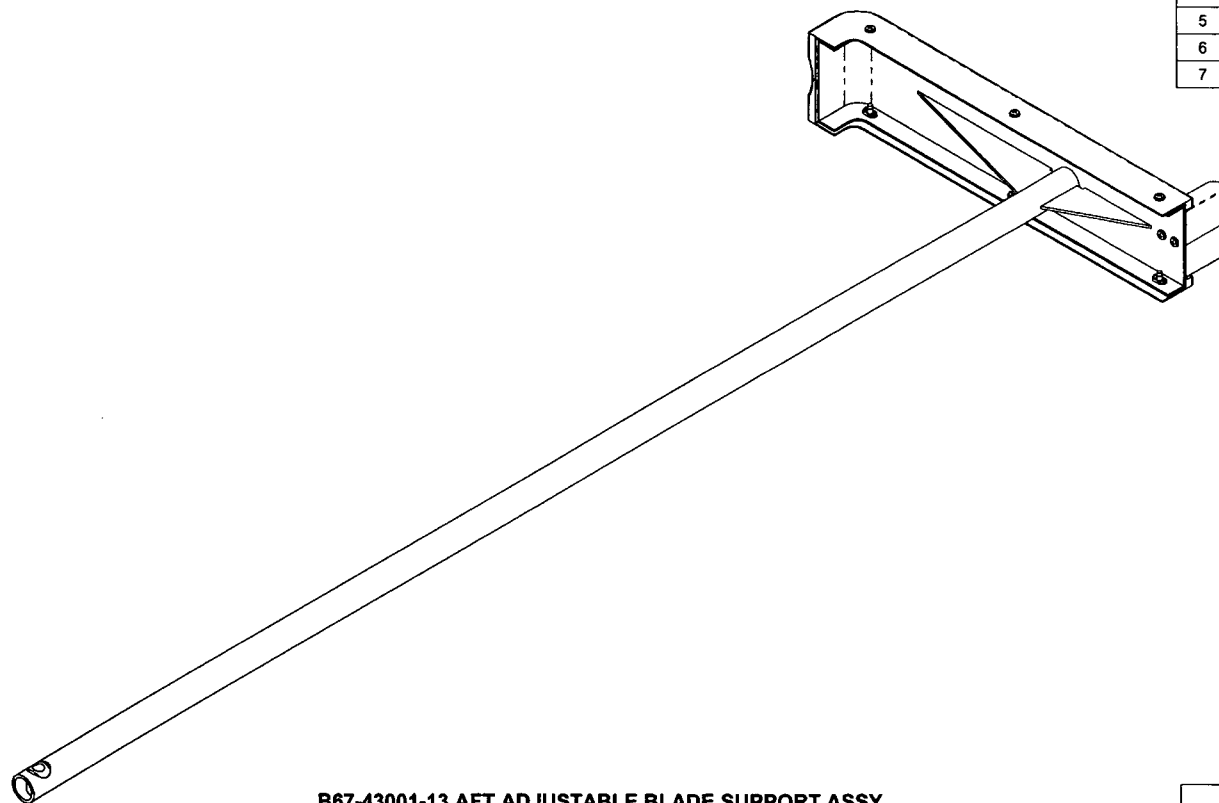
100022

16

Thursday, January 09, 2014 11:28:40 AM

Shop Packet Print

Page 3



B67-43001-13 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -13	P/N	DESCRIPTION
1	X	B67-43001-13	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

ME
11/15
14-01-09

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-13 REV. C SHEET 1 OF 2 TITLE AFT ADJUSTABLE BLADE SUPPORT ASSY SCALE NTS DATE 10.04.28 COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	N/A			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

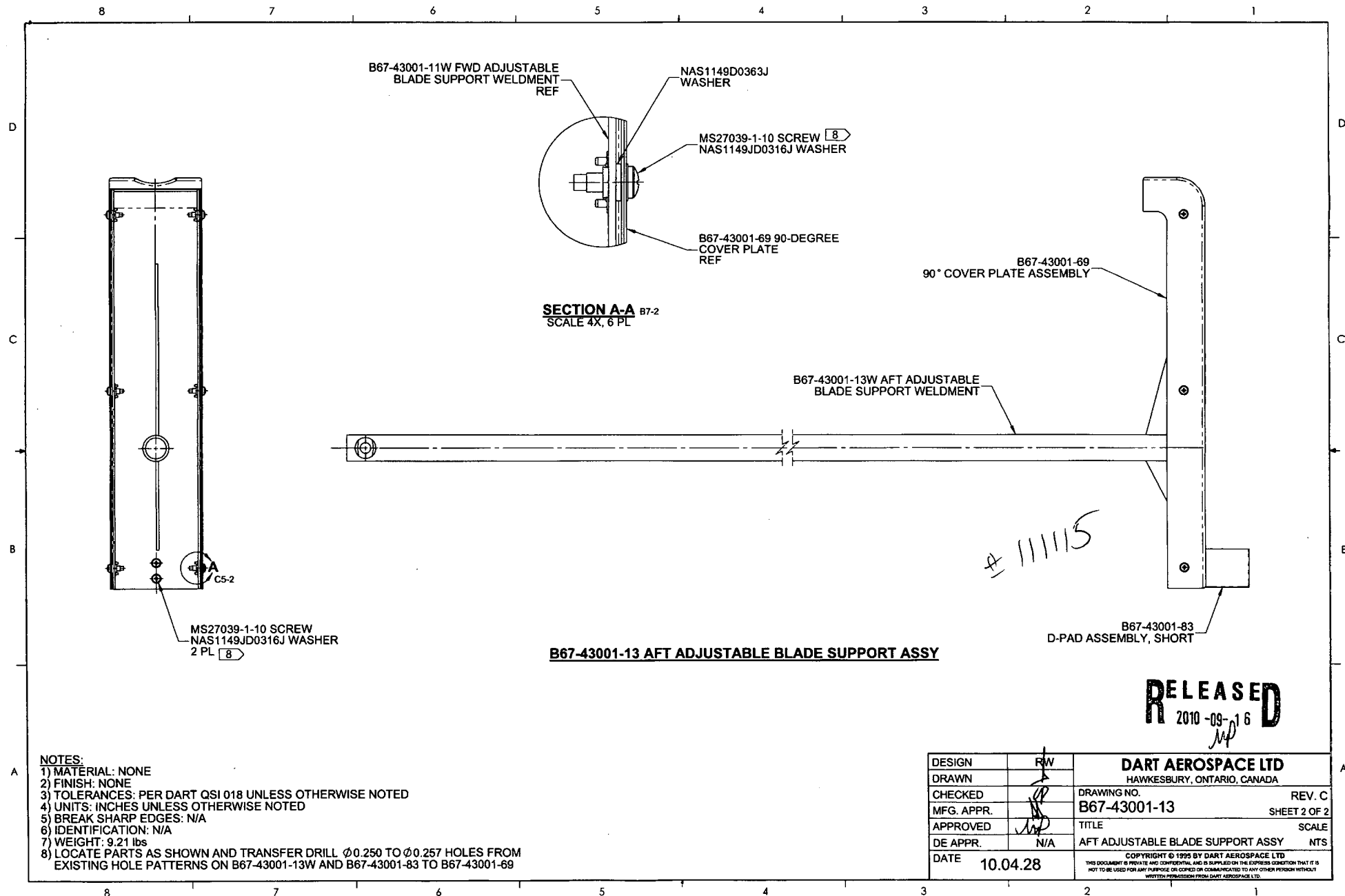
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

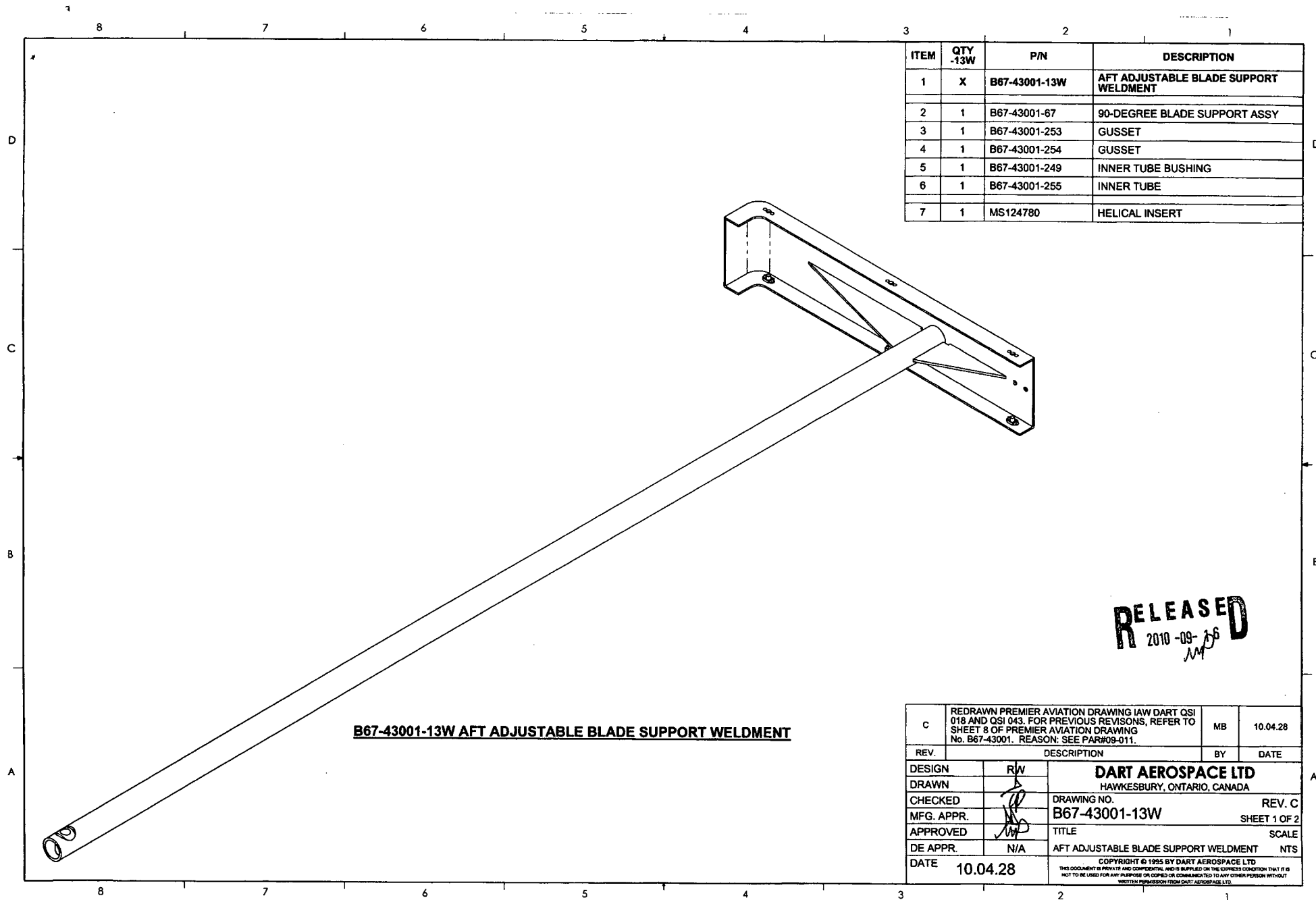
Work Order update only ☐

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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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ITEM	QTY -13W	P/N	DESCRIPTION
1	X	B67-43001-13W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-253	GUSSET
4	1	B67-43001-254	GUSSET
5	1	B67-43001-249	INNER TUBE BUSHING
6	1	B67-43001-255	INNER TUBE
7	1	MS124780	HELICAL INSERT

B67-43001-13W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-15

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR909-011.		MB	10.04.28
REV.	DESCRIPTION			BY	DATE
DESIGN	R/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-13W TITLE AFT ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS		REV. C	
DRAWN				SHEET 1 OF 2	
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.	N/A				
DATE	10.04.28			COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

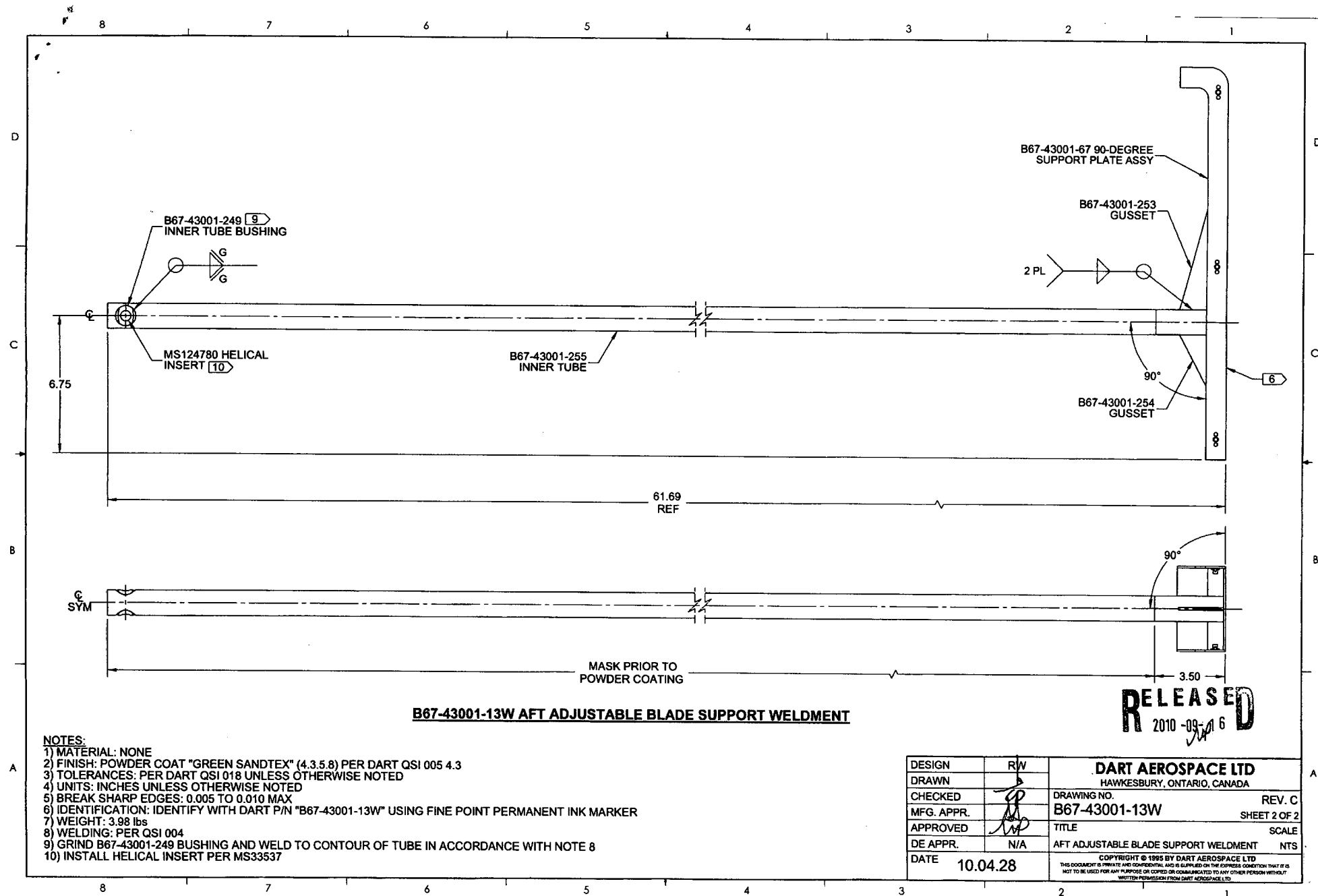
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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